







Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHOULDER HARNESS KIT
Job Number : 36297	
Estimate Number : 13048	
P.O. Number : N/A	Part Number : D350764011
This Issue : 12/13/2007 S.O. No. : N/A	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 35724	Material : N/A
Written By : <u> </u>	Due Date : 1/5/2008
Checked & Approved By : <u> </u>	Qty: 2 Um: Each
Comment : EST REV:A New issue 07-10-11 DD verified by EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	DC DOCUMENT CONTROL
	
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D350-764-011 CHG001 <u>07/12/13</u>	
2.0	PACKAGING 1 PACKAGING RESOURCE #1
	
Comment: PACKAGING RESOURCE #1	
X 3.0	D2854 3/4" Velcro
	
Comment: Qty.: 2.6660 f(s)/Unit Total : 5.3320 f(s) 3/4" Velcro Cut qty 4 D2854-1-080 (8" each) as per dwg D2854 Batch: <u>B35121</u> <u>07/12/14</u> (X2)	
X 4.0	D2854 3/4" Velcro
	
Comment: Qty.: 2.6660 f(s)/Unit Total : 5.3320 f(s) 3/4" Velcro Cut qty 4 D2854-3-080 (8" each) as per dwg D2854 Batch: <u>B35121</u> <u>07/12/14</u> (X2)	
X 5.0	D3578041 DOUBLER
	
Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s) DOUBLER <u>B35737</u> <u>07/12/14</u> (X2)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 36297

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D363611

SHOULDER BELT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
SHOULDER BELT

B35393

AS 07/12/14 (X2)

7.0

D363613

LAP BELT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
LAP BELT

B35394

AS 02/12/14 (X2)

8.0

D3637041

BRACKET ASSEMBLY



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
BRACKET ASSEMBLY

B34537 5X 12/14/18

AS 07/12/14 (X2)

9.0

D36373

BRACKET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
BRACKET

B35389

AS 07/12/14 (X2)

10.0

D36381

BUSHING (Replaces G10608-2)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
BUSHING

B35388

AS 02/12/14 (X2)

11.0

D36391

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
DOUBLER

B34538

AS 02/12/14 (X2)

12.0

D36392

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
DOUBLER

B34539

AS 07/12/14 (X2)

13.0

D36393

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
DOUBLER

B34540

AS 07/12/14 (X2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 11:20:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 36297

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D36394

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
DOUBLER

B34541

AS 07/12/14 (X2)

15.0

D36401

BELT GIUDE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
BELT GIUDE

B34558

AS 07/12/14 (X2)

16.0

D36403

BELT GIUDE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
BELT GIUDE

B34559

AS 07/12/14 (X2)

17.0

D36411

COVER (Replaces G10606-3/-6)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
COVER

B35384

AS 07/12/14 (X2)

18.0

D36413

COVER (Replaces G10606-5)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
COVER

B34543

AS 07/12/14 (X2)

19.0

D36414

COVER (Replaces G10606-4)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
COVER

B35385

AS 07/12/14 (X2)

20.0

D36421

DOUBLER (Replaces G10607-1/-2)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
DOUBLER

B34545

AS 07/12/14 (X2)

21.0

D36422

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
DOUBLER

B34546

AS 07/12/14 (X2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 36297

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D36431

STIFFENER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

STIFFENER

~~B34547~~ B34547

AS 07/12/14

(X2)

23.0

D36432

STIFFENER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

STIFFENER

B34548

AS 07/12/14

(X2)

24.0

D36441

SHIM



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

SHIM

B35592

AS 07/12/14

(X2)

25.0

D36571

GUIDE TOOL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GUIDE TOOL

B34550

AS 07/12/14

(X2)

26.0

ALS41032130

Insert



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Insert

M105730

AS 07/12/14

(X2)

27.0

AN33A

Bolt



Comment: Qty.: 32.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

M106537

AS 07/12/14

(X2)

28.0

AN36A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

M100184 X 30

AS 07/12/14

(X2)

29.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

M104603

AS 07/12/14

(X2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 36297

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

AN960JD10

Washer



Comment: Qty.: 48.0000 Each(s)/Unit Total : 96.0000 Each(s)
Washer

M105792

AS 07/12/14

(X2)

31.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

M105906

AS 07/12/14

(X2)

32.0

AN960JD616

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

M105906

AS 07/12/14

(X2)

33.0

AN9706

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

M10538-21

AS 07/12/14

(X2)

34.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)
Cherry Rivet

M103525

AS 07/12/14

(X2)

35.0

CR321242

Cherry Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Cherry Rivet

M106303

AS 07/12/14

(X2)

36.0

CR3212504

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Rivet

M106321

AS 07/12/14

(X2)

37.0

CR3212507

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Rivet

M105970

AS 07/12/14

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 36297

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

MS20426AD33

Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 64.0000 Each(s)
Rivet

~~M19099~~ AS 07/12/14 (x2)

39.0

MS20426AD44

Rivet



Comment: Qty.: 106.0000 Each(s)/Unit Total : 212.0000 Each(s)
Rivet

~~M1621~~

AS 07/12/14 (x2)

40.0

MS20426AD46

Rivet



Comment: Qty.: 28.0000 Each(s)/Unit Total : 56.0000 Each(s)
Rivet

M103395

AS 07/12/14 (x2)

41.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
Rivet, Universal Head

M105408

AS 07/12/14 (x2)

42.0

MS21059L3

Nut Plate



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)
Nut Plate

M101588

AS 07/12/14 (x2)

43.0

MS21072L3

Nutplate



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
Nutplate

~~M10728~~

AS 07/12/14 (x2)

44.0

MS35206267

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
Screw

M105510

AS 07/12/14 (x2)

45.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/12/15 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/12/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 11:20:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 36297

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-764-011

Location: B

PPP Rev: 7/12/19 SD (2A)

47.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

08/12/19

Job Completion



u 07-12-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 11:20:55 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHOULDER HARNESS KIT
Job Number : 36297	
Estimate Number : 13048	
P.O. Number :	Part Number : D350764011
This Issue : 12/13/2007 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 35724	Material :
Written By :	Due Date : 1/5/2008 Qty: 2 Um: Each
Checked & Approved By : <u>07.12.13</u>	
Comment : EST REV:A New issue 07-10-11 DD verified by EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-764-011 CHG001

07.12.13

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3.0	D2854	3/4" Velcro
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Comment: Qty.: 2.6660 f(s)/Unit Total : 5.3320 f(s)

3/4" Velcro

Cut qty 4 D2854-1-080 (8" each) as per dwg D2854

Batch: _____

4.0	D2854	3/4" Velcro
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Comment: Qty.: 2.6660 f(s)/Unit Total : 5.3320 f(s)

3/4" Velcro

Cut qty 4 D2854-3-080 (8" each) as per dwg D2854

Batch: _____

REFERENCE ONLY

5.0	D3578041	DOUBLER
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

DOUBLER